

Date: Monday, 05/01/2009 3:24:01 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 212 X-TUBE ,LOW STANDARD AFT
 Job Number : 44384
 Estimate Number : 13019
 P.O. Number :
 This Issue : 05/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D212664207
 First Issue : / / Type : CROSSTUBES Drawing Number : D212-664-247
 Previous Run : 42878 Project Number : N/A
 Material : A
 Due Date : 23/01/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JLD 09.01.05
 Comment : Est Rev:A New Issue 07.09.12 EC verified by: JLM
 Est Rev:B ECN 1100p 08-01-11 DD verified by: EC
 Est Rev:C ECN 1121 08-02-25 DD verified by:
 Est Rev: D QC5 replaced by QC15 at step 5 KJ Verified by:

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



for JLD 09/01/22



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-207 CHG001

S 09/01/22

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0

D212664207TRN

Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch *1-43330*

MB 09-01-12

4.0

BENDING

BENDING MACHINE - SKIDTUBES



MB 09-01-12



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-247 using CNC bender program and Folio FT

5.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

S 09/01/12 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 05/01/2009 3:24:01 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW STANDARD AFT

Job Number: 44384

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D36601

CUFF



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

CUFF

Batch:

B-36651 (1)

B-36835 (1)

MP 09-01-12

7.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Rivet holes as per Dwg D212-664-247 using DT8972.

2-Drill pilot holes in tube as per Dwg D212-664-247

3-Ream hole to finish size in tube as per Dwg D212-664-247

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-247

4-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-247

850
8551

MP 09-01-13

MP 09-01-13

MP 09-01-13

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1

MP

09-01-13

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8 09/01/14 (80)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

check rivet holes with
cuff &

8 09/01/14 (40)

11.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 8500 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

W 09/01/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 05/01/2009 3:24:01 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW STANDARD AFT

Job Number: 44384

Part Number: D212664207

Job Number:



Seq. #: Machine Or Operation: Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

Py/d/9 (C)

13.0

QC5

INSPECT WORK TO CURRENT STEP



ml 09 01 19



(1)

Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

14.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet Cuffs as per Dwg D212-664-247. with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/-291

BATCH:

109883 exp 09-07-01

RT 09-01-19

15.0

CR3212406

CHERRY RIVET



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

CHERRY RIVET

Batch:

104093 x9 / 103688 x11 / 106863 x21 / 107316 x3

RT 09-01-19

16.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

RT 09-01-21

17.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

ml 09 01 21

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 05/01/2009 3:24:02 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW STANDARD AFT

Job Number: 44384

Part Number: D212664207

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

18.0	D29401	Support
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Support

batch: 38128 418 70

ml 09 01 21

19.0	D3595063530	RUBBER CUSHION
------	-------------	----------------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Rubber Cushion

Batch: 40780

ml 09 01 21

20.0	MS2192028	Clamp(per MIL-DTL-8783C)
------	-----------	--------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Clamp

Batch: 109181

ml 09 01 21

21.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Assemble as per Dwg D212-664-247

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3- Instal support with magnobond 6398 per dwg D212-664-247,
cure for 12hrs before packaging.

Time & date of application: 3:45pm 09/01/21

Batch: 109900

EXP. DATE 02/2010

80-100 Torque; ml 09 01 22 (1)
ml 09 01 21 (1)

22.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

23.0	AN640A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

batch M110267

09/01/22 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Monday, 05/01/2009 3:24:02 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW STANDARD AFT

Job Number: 44384

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch M109371

25.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

batch M108183

26.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

batch M110002

27.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

batch B32448

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-207

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Mf 09-01-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

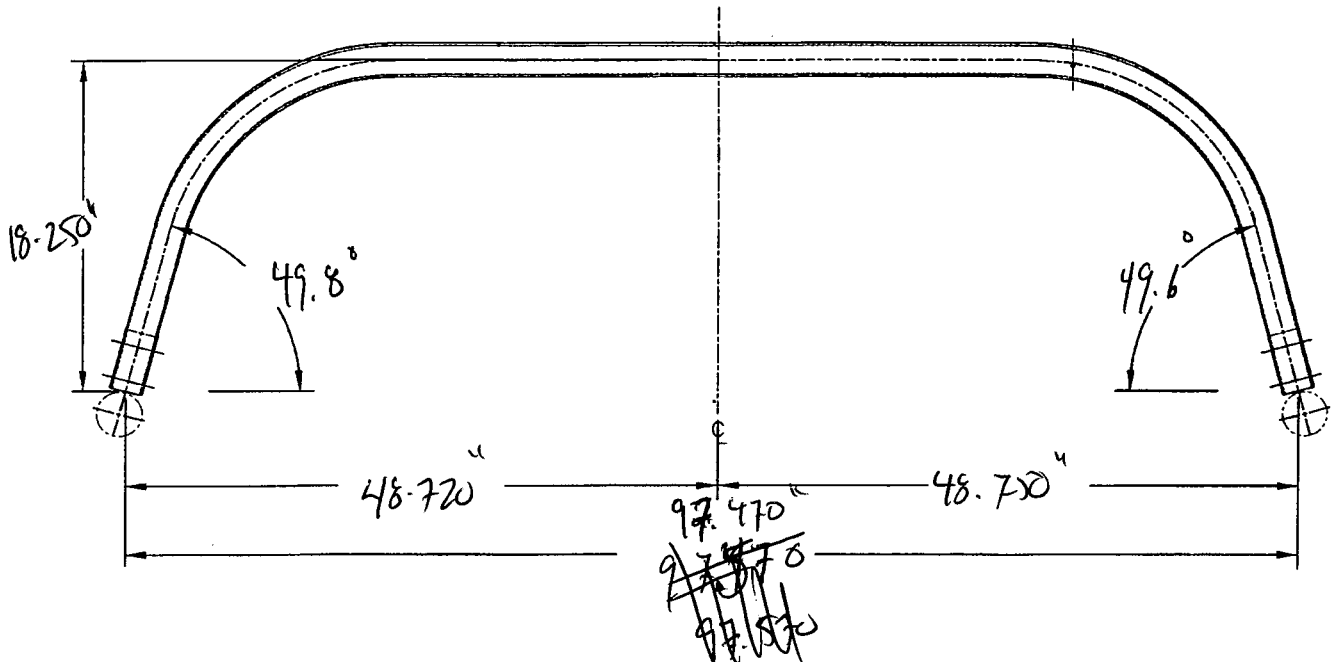
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	44384
Description: Crosstube Low Aft (205/212)		Part Number:	D212-664-207
Inspection Dwg: D212-664-247 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	18.16	18.42
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62



Comments

QC15 Inspection	S
Date	08/01/12

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/JM	[Signature]

PARTS LIST:

Qty	Part Number	Description
X	D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
1	D6008-132	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
2	D3660-1	CUFF
4	MS21920-28	CLAMP (OR MS21920-30)
44	CR3212-4-06	RIVET (OR M7885/3-4-06)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6008-132
FINISHED LENGTH = 128.27±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE.
- 6) WHEN MACHINING TAPER, RUN-OFF PART AT STOCK. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 7) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 8) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 9) SCRIBE DART PART NUMBER AND BATCH NUMBER ON INNER SURFACE OF TUBE WITH A
VIBRATING STYLUS.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1
THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE
D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE
CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY
AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 14) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A
LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN
CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

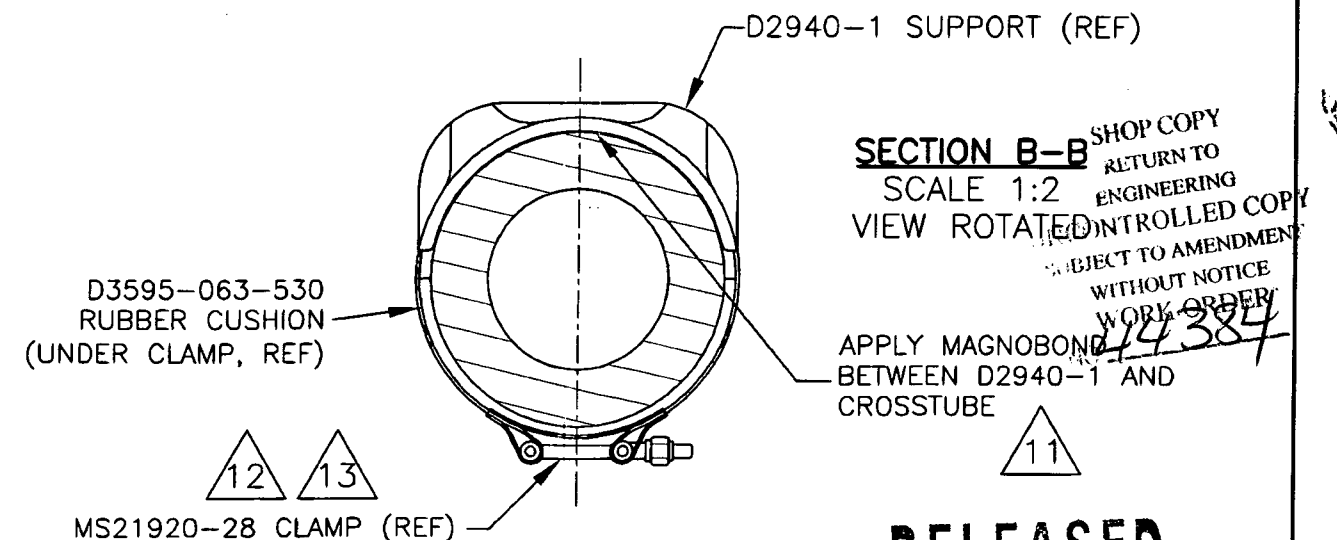
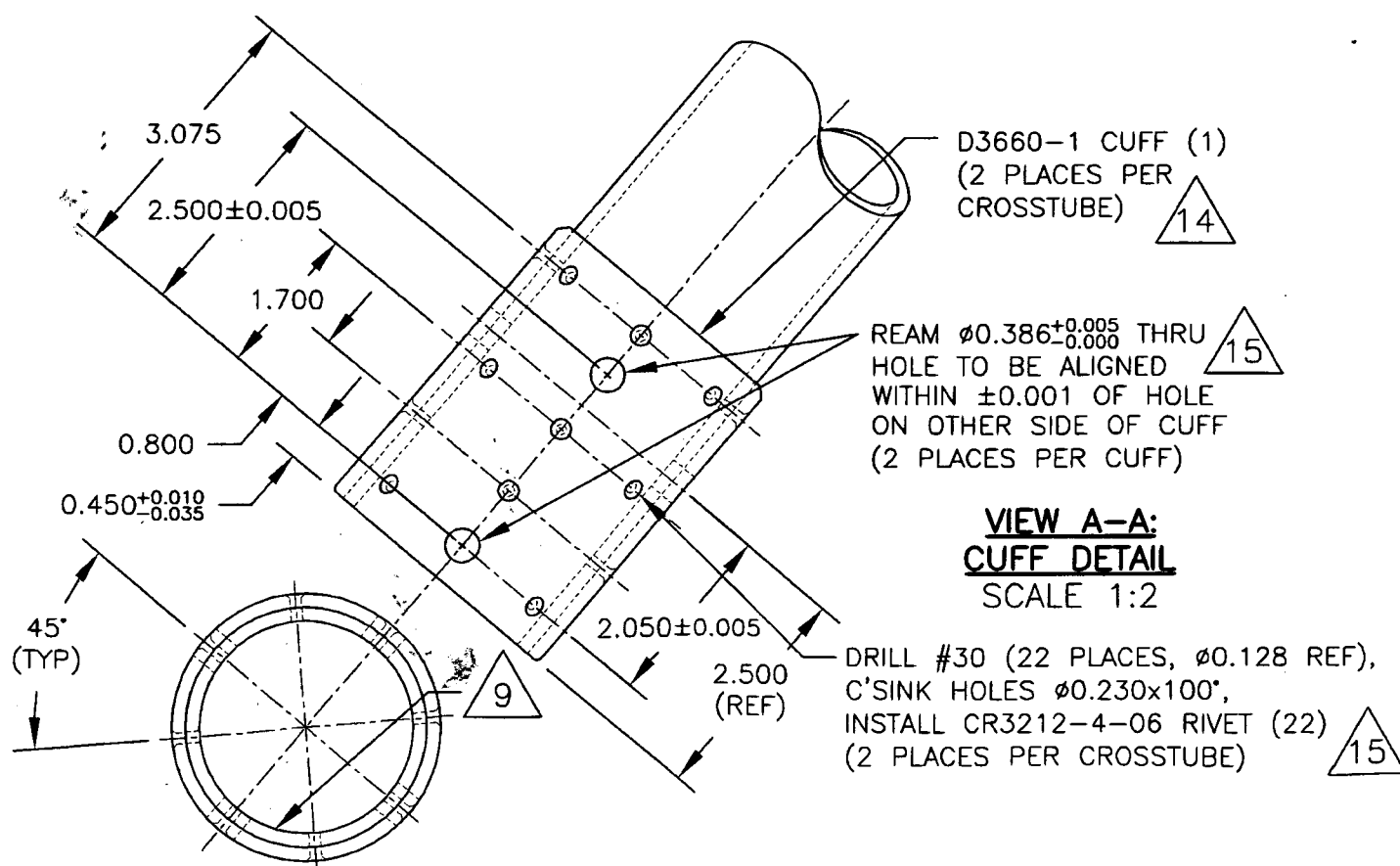
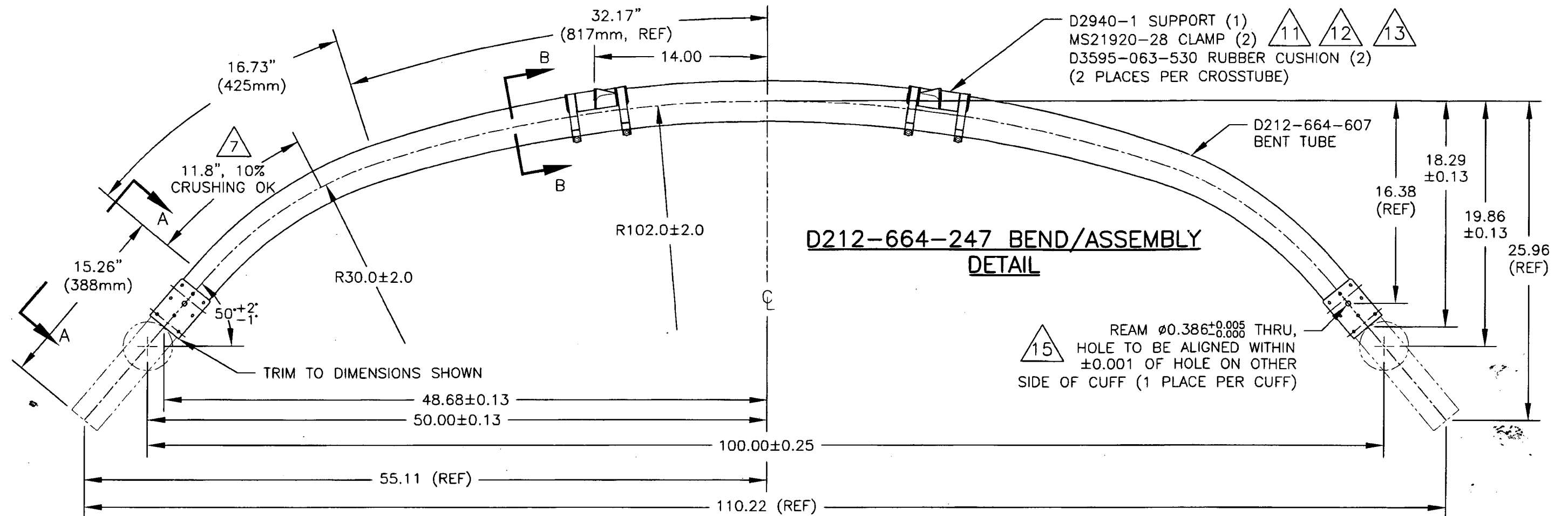
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 44384

RELEASED
07.07.07

A		07.07.07	NEW ISSUE
DESIGN		DRAWN BY	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED	DRAWING NO. REV. A
DATE			D212-664-247 SHEET 1 OF 3
07.07.07			TITLE SCALE
			CROSSTUBE (205/212 LOW AFT) NTS

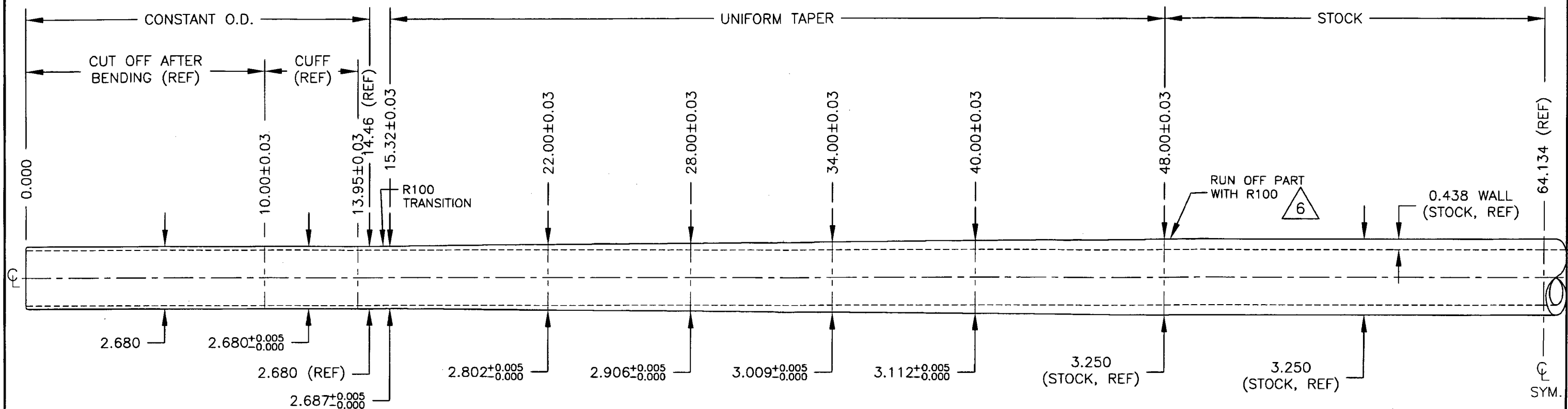
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07.09.24

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		DATE	07.07.07			D212-664-247	SHEET 2 OF 3
						TITLE	SCALE
						CROSSTUBE (205/212 LOW AFT)	1:8



D212-664-247 MACHINING DETAIL

RELEASED
07.09.24

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NO. 44384

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DATE 07.07.07		DRAWING NO. D212-664-247		REV. A SHEET 3 OF 3		SCALE 1:4
		TITLE CROSSTUBE (205/212 LOW AFT)				



LIQUID PENETRANT TEST REPORT

P- 149

PAGE 1 OF

CLIENT DART AEROSPACE DATE JAN 16-2009 TIME AM ☐ PM ☐
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-09-001278
ADDRESS 1270 ABERDEEN ST PO/VO No. 8000
HAWKES BURY ONT WORK LOCATION MAIN SHOP-HAWKES
ACCEPTANCE STD. ASTM1417 REV./DATE 200
PROJECT X-TUBES QSI-038
ITEM(S) EXAMINED 7 ITEMS. FLUORESCENT DIE

JOB DESCRIPTION PROCEDURE NO. LT-XXX REV./DATE TECHNIQUE No. LT-XXX-XXX REV./DATE

PART NO. MATERIAL ALODINED ALUM THICKNESS
SCOPE WET FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON 100% EXTERNAL

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EM
FAMILY BRAND MACNAFLUX BLACK LIGHT S/N 8171 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT
PENETRANT ZL 67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @
PENETRANT REMOVER H2O MINIMUM DRY TIME > 10 MIN. OTHER
DEVELOPER SK052 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE FES
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE ME
SURFACE TEMPERATURE ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)
PART IDENTIFICATION
1 - B-44125-443052 SC 1 44215
1 - B-44156-44193 ✓
1 - B-44155-44192 ✓
1 - B-44378-44139 ✓
1 - B-44379-44140 ✓
1 - B-43330-44384 ✓
1 - B-43051-44214 ✓
AN INDICATION WAS LOCATED ON
THIS PIECE. WILL BE SANDED TO
COMPLY, AND REEXAMINED AT
LATER DATE.

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly
that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be co-
representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as
data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.
Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, exp-
implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE Julie Dawson DTR # 19804
TECHNICIAN (SIGNATURE): Mike Johnston REPORT REVIEWED BY:
NAME (PRINT): Mike Johnston NAME INIT
CGSB LEVEL II SNT LEVEL CGSB LEVEL SNT LEVEL
CGSB REG. No 0666 CGSB REG. No



Client: DART AEROSPACE
Contact: LINDA LACELLE
Location: 1270 ABELDEEN
Description: X-TUBES, 7 PCS.
Report #'s: F. LPI

E- 19804

Form dated Sep 2005

Job #: 188-04-001278
Day: Sun Mon Tues
P.O. #: _____
Vehicle # 579

Date: JAN-16-2009
 Wed Thurs (Fri) Sat
 W.O #: 108-09-001278
 Camera #:

[illegible]

RADIOGRAPHIC UNIT PRICING																					
Weld Diameter										Long Seam						Circ. Seam					
Schedule / Thickness										Thickness						Thickness					
Quantity										Lineal Ft.						Lineal Ft.					

Film: _____ Pcs. 2 3/4 x 17"
 _____ Pcs. 3 1/2 x 17"
 _____ Pcs. 4 1/2 x 17"
 _____ Pcs. 14" x 17"
 _____ Pcs.

Consumables:

Equipment:

Client Representative:

WET FLUORESCENT.
AS PCL -

Place a check mark in each safety check area as completed	
C/C	CAMERA CHECK
S/E	SAFETY EQUIPMENT CHECK
S/C	SURVEY METER CHECK
B/S	BARRRIER & SIGN INSTALLED
C/L	CAMERA LOCKED & SECURELY STORED
C/S	CAMERA SURVEYED AFTER EACH USE

EXPENSES

NOTES

ACUREN 1-877-299-2857

Oakville	(905) 825-8595 • Fax (905) 825-8598
Sarnia	(519) 336-3021 • Fax: (519) 336-8220
Sudbury	(705) 522-1849 • Fax (705) 522-9926
Halifax	(902) 497-3870 • Fax (902) 445-5090
North Bay	(705) 840-8107 • Fax (705) 476-6683
Val D'Or	(819) 856-6789 • Fax (819) 825-9564

Cambridge	(519) 622-3112 • Fax (519) 622-1326
Cornwall	(613) 931-1261 • Fax (613) 931-2777
Saint John	(506) 847-0194 • Fax (506) 847-0194
Thunder Bay	(807) 475-4240 • Fax (807) 577-2017
Gaspé	(418) 392-3618 • Fax (418) 392-4114
Hull	(819) 360-0685 • Fax (819) 827-3513